

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013368**Date Inspected:** 11-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Yang Qing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment 9CW**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT)

This QA inspector performed Visual Testing (VT) on OBG Segment and VT indications are confirmed by Magnetic Particle Testing on area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 9CW. The weld designations reviewed are as follows:

OBG Segment 9CW-PP79 West side

1. FB009-027-003
2. FB003-152-005
3. FB015-034-001

OBG Segment 9CW-PP78 East side

1. FB015-030-002
2. FB003-014-004

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Trial Assembly Area

SMAW in the 1G position for the OBG Segment 5CE, weld No.SEG026A-008. The welder is identified as #066179. ZPMC QC is identified as Mr. Yang Qing. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1. The weld repair report is identified as B-CWR-1201.

Heat Straightening

During in process inspection the QA Inspector observed that the ZPMC personal doing heat straightening on butt weld joint joining at Segment 5CE side plate SP306A to SP425A bike path side .The weld joint is identified as SEG026A-010 . And the heat straightening report identified as HSR(B)-353.

After Blast Inspection

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 7DW internal side panel, bottom panel, floor beam and longitudinal diaphragms surfaces from the panel point 56 to 57 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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